

Work Order ID 156336***156336***

Page 1

Friday, January 27, 2017 1:28:43 PM

Item ID: D4634-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Middle, Center Ceiling Panel Assembly
Start Date: 1/13/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/27/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date FEB 01 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								DAS 07 9-89
100		0.00							
100									
HandThermo	Memo	0.00				<u>x/</u>			17/03/16
Hand Finishing Thermoforming	Pick Kit								
110		0.00							DAS 07 9-89
110									
Small Fab	Memo	0.13				<u>x/</u>			17/03/16
Small Fab	***BEFORE INTALLING D4728-051, APPLY A 3/16" SEEM OF PLASTIC- WELD 2 ON TOTAL LENGHT OF PART ON EANCH SIDE OF LIGHT, LET DRY FOR ONE HOUR*** PLASTIC-WELD 2 BATCH : <u>137023</u>								
	1- Assemble as per Dwg D4634-043								
	2- Install led lights								
	3- Install Air valves								
	4-Install wiring harness								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									DAS
QC	Memo	0.00				1			38
Quality Control									9-89
									APR 18 2017
130	Identify as per dwg & Stock Location: PK6	0.00							
130									DAS
Packaging	Memo	0.00							6
Packaging									9-89
									JUN 07 2017
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									17/6/12



JUN 07 2017

DQA: _____ Date: _____



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Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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156336

D4634-043

Required Qty: 1.00

Comments:	IPP Rev. A 12/08/09 New Issue DL	IPP Rev B
	12/11/08 Document release DL VERIFIED BY:JLM	IPP Rev C 13/07/09
	Dwg Update DL verf: DD	IPP Rev D Dwg Update 13/12/23
	DL	IPP REV E Dwg update 14/01/09
	DL	IPP Rev F Dwg. update 14/02/03
	DL	IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4652-5		Manufactured	No			100	Each	0.0000	2	2			
D4652-5									**	(2)			DAS 07 9-89
Air Valve, 1.25 Id Disk Type													
D4634-143		Manufactured	No			100	Each	0.0000	1	1			
D4634-143									**	(1)			17/03/16 DAS 07 9-89
Middle, Center Ceiling Replacement Panel Assembly													
D4646-1		Manufactured	No			100	Each	22.0000	2	2			
D4646-1									**	(2)			17/03/16 DAS 07 9-89
Plenum Cap Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF009				22					
				(154711)				22		(2)			
D4728-053		Manufactured	No			100	Each	14.0000	1	1			
D4728-053									**				DAS 07 9-89
Cabin Lights #2													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF001				2					
				(122551)				2		(1)			
				over001				12					
				122551				12					17/03/16

DQA: _____ Date: _____



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OTHER : ☐					

Picklist Print

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Work Order ID: 156336

156336

Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 1/13/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

PLT1.5M-M

Purchased

No

100

Each

2,675.000

3

3

PI T1 5M-M

Tie Wrap

DAS
07
9-89

17/03/16

Location

Loc Qty

Loc Code

ST585

2675

m129712

2675

2351-20-27-C3C

2351-20-27-
Z3CT

Purchased

No

100

Each

47.0000

2

2

2351-20-27-C3C

STUD

DAS
07
9-89

17/03/16

Location

Loc Qty

Loc Code

ST579

47

m128068

3

m130318

44

50-009-2

Purchased

No

100

Each

43.0000

2

2

50-009-2

Grommet

DAS
07
9-89

17/03/16

Location

Loc Qty

Loc Code

ST583

43

m135442

43

DQA: _____ Date: _____



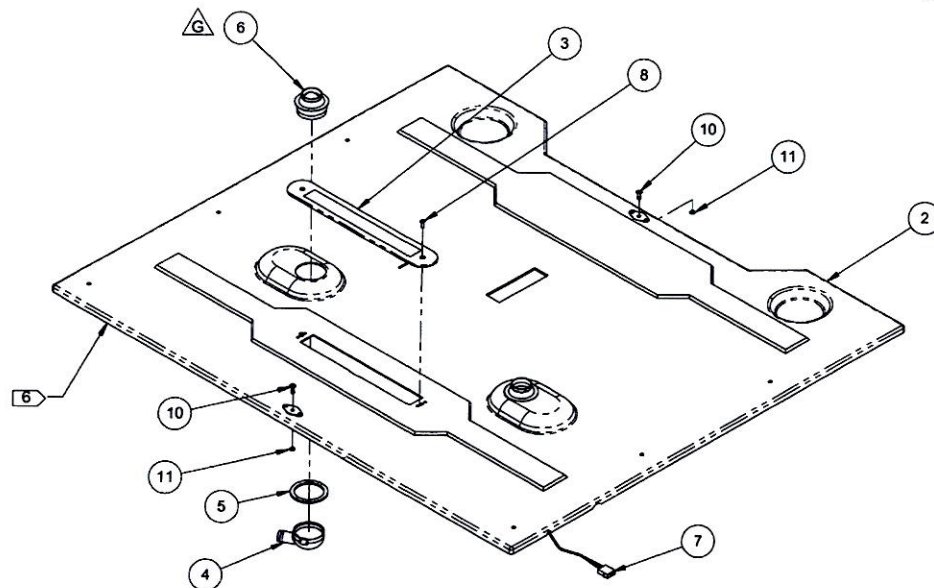
WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER :					

ITEM NO.	QTY. -043	P/N	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-053)
4	2	D4646-1	PLENUM CAP ASSEMBLY
5	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
6	2	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
7	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
8	2	N/A (REF)	SCREW (PART OF D4638-1)
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
10	2	2351-20-27-C3C	DZUS STUD, OVAL HEAD
11	2	50-009-2	GROMMET



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 156336 MWS
170201

RELEASED

2015 JAN 26 *up*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D4634	REV. G
MFG. APPR.	DL	SHEET 3 OF 17	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	
DATE	14.11.28	NTS	

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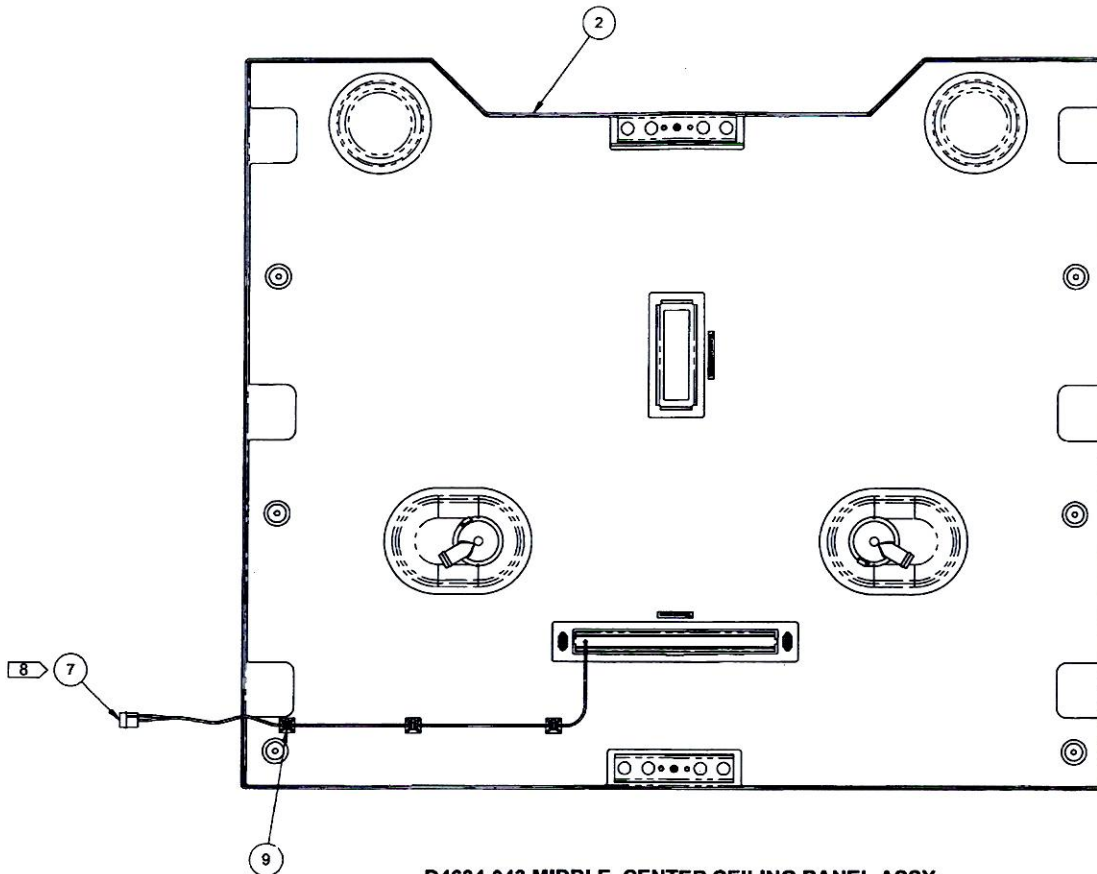
8 7 6 5 4 3 2 1

D

C

B

A



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED
2015 JAN 26

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D4634	REV. G
MFG. APPR.	DL	SHEET 4 OF 17	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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8 7 6 5 4 3 2 1